

Ship Friday 14/05

Work Order ID 58642

May 12, 2010 1:47:43 PM



Page 1

Item ID: D3393-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Battery Lock Assembly

Start Date: 5/12/10

Start Qty: 2.00



Required Date: 5/14/10

Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3393

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2-Using the flat cam, fabricate D3369-5 as per Dwg D3369-5. 3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten

SB 10/05/17

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Tack Weld lock shaft to flat cam of a Max 1/8" Long. QtyPart Number Description Batch# A/RN/A SS Rod M108/60

EL 10-5-17 (L)

120

0.00



QC9- Inspect visual per QS1004- Fusion Welds

QC

Memo

0.00

Quality Control

QC 10-05-17

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58642

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Page 2

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Item Name: Battery Lock Assembly

Start Date: 5/12/10 Start Qty: 2.00



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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

Apply Crazy Glue to cap and press into Body 19567K21
Batch: M114655

8n 10/05/17

②

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

5 10/05/17

④2

150



Packaging

Packaging

Identify as per dwg & Stock Location: 426

Memo

0.00

0.00

10-5-17 ②x 5

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58642

May 12, 2010 1:47:43 PM



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Item ID: D3393-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Battery Lock Assembly

Start Date: 5/12/10 Start Qty: 2.00



Cust Item ID:

Required Date: 5/14/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/17

U 10/05.17

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 12, 2010 1:47:42 PM

Page 1

2

Work Order ID: 58642

Parent Item: D3393-041

Parent Item Name: Battery Lock Assembly

Comments: IPP Rev:A New Issue 05-11-22 JLM

Start Date: 5/12/10

Required Date: 5/14/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

5/16WC		Purchased	No			100	Each	364.0000	2			
--------	--	-----------	----	--	--	-----	------	----------	---	--	--	--



SS Flat Washer 5/16

1114678

Location	Loc Qty	Loc Code
----------	---------	----------

ST377	364	
112560	364	

9567K21		Purchased	No			100	Each	89.0000	2			
---------	--	-----------	----	--	--	-----	------	---------	---	--	--	--



Polyethelene Cap

Location	Loc Qty	Loc Code
----------	---------	----------

ST380	89	
110822	89	

D2728-7		Manufactured	No			100	Each	0.0000	0			
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Dart Logo label

D3373-1		Manufactured	No			100	Each	9.0000	1			
---------	--	--------------	----	--	--	-----	------	--------	---	--	--	--



Cam Lock

B58463

Location	Loc Qty	Loc Code
----------	---------	----------

ST052	9	
44105	9	

D3393-1		Manufactured	No			100	Each	0.0000	1			
---------	--	--------------	----	--	--	-----	------	--------	---	--	--	--



Battery Lock Casing

B58440

4 SN 10/05/17 (2)

13

SN 10/25/17 (2)

~~2070~~ 4 SN 10/05/17 (2)

(2) SN 10/05/17 (2)

2 SN 10/05/17 (2)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

May 12, 2010 1:47:42 PM

Page 2

Work Order ID: 58642

Parent Item: D3393-041

Parent Item Name: Battery Lock Assembly

Start Date: 5/12/10

Required Date: 5/14/10

Comments: IPP Rev:A New Issue 05-11-22 JLM

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3393-3		Manufactured	No			140	Each	17.0000	1			



Cam Lock Shaft



Location

Loc Qty

Loc Code

ST055

17

48630

17

Sb 10/05/17 (2)

2

May 12, 2010 1:47:42 PM

Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

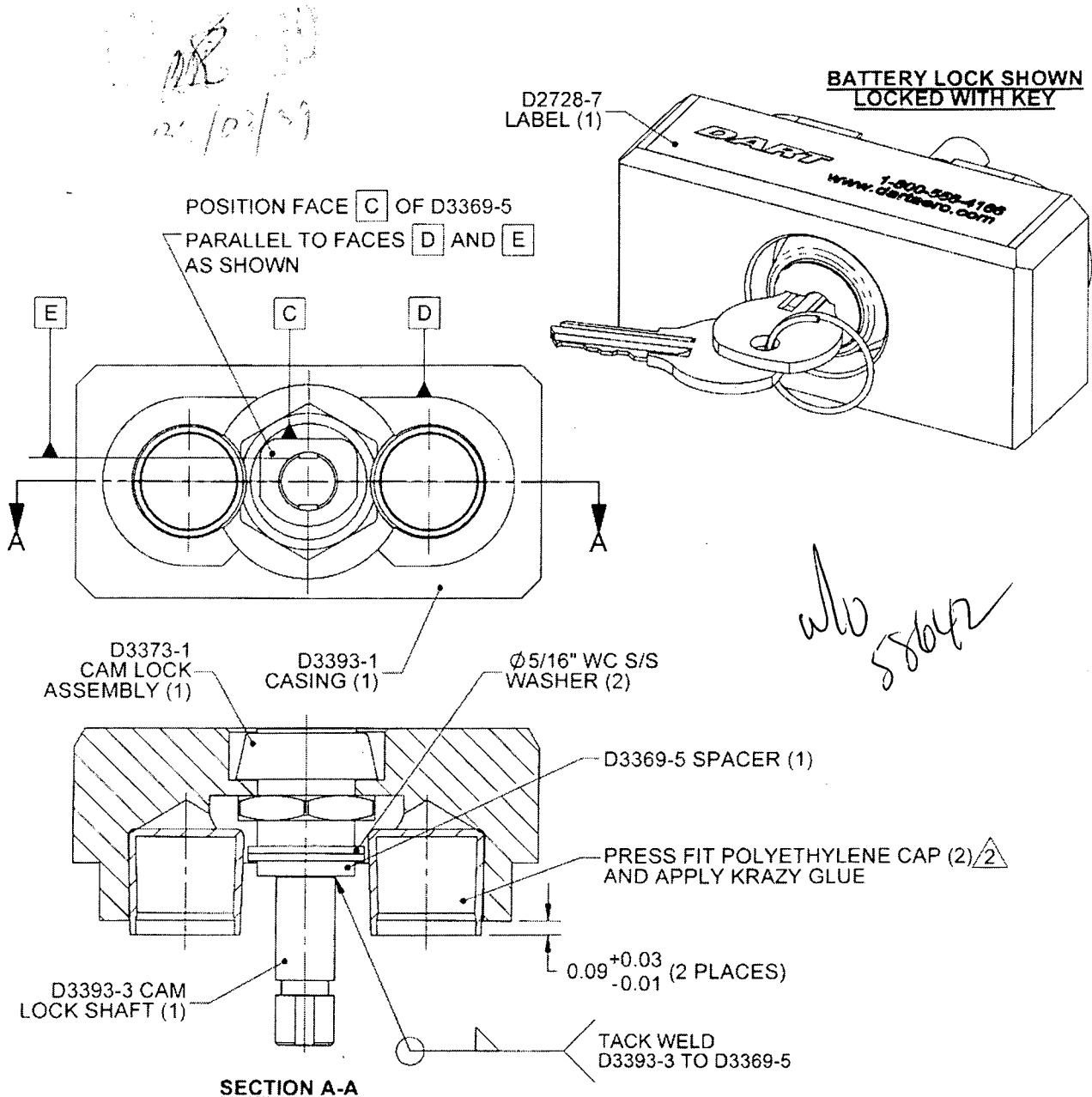
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	
A	05.02.08	NEW ISSUE	



D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

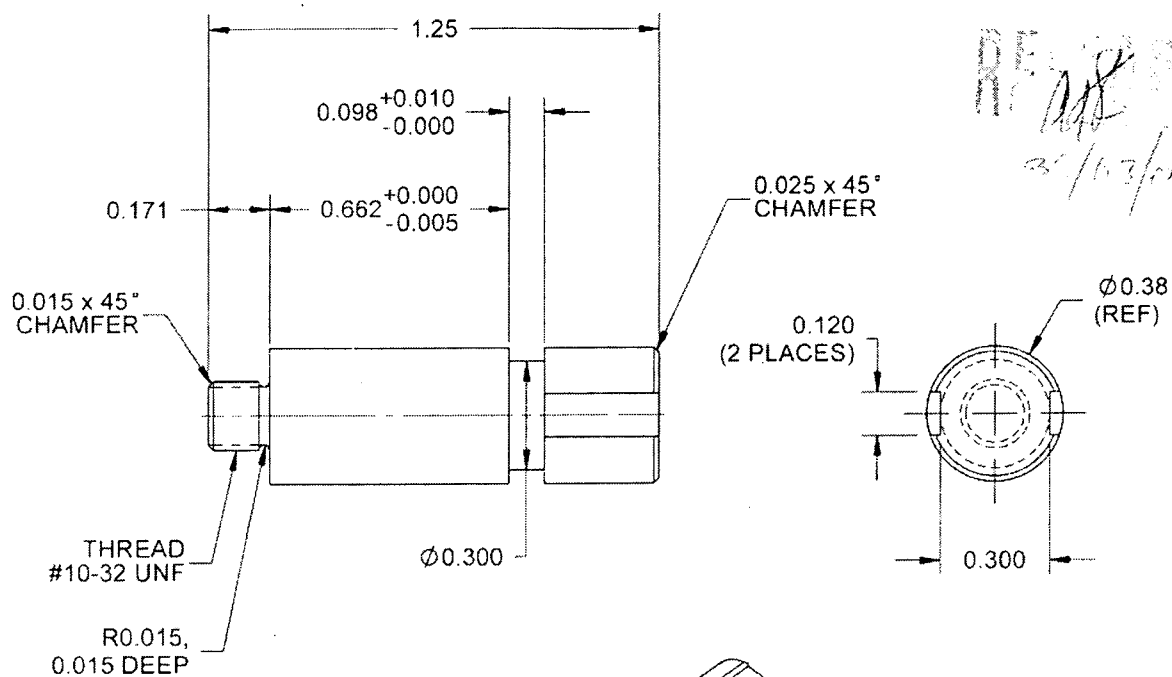
- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

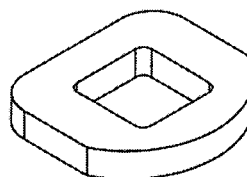
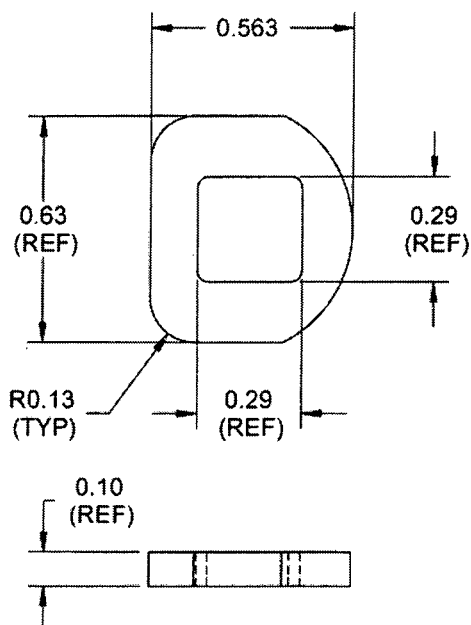
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16	TITLE BATTERY LOCK		SCALE 2:1

SPECIFICATION CONTROL DRAWING



RELEASED
[Signature]

05/02/11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58642

P/10-5-17

-5
D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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